

Work Order ID 53920

November 23, 2009 2:49:34 PM

Page 1

Item ID: D3886-041

Revision ID: B

Item Name: Lug Assembly

Start Date: 23/11/2009 Start Qty: 4.00

Required Date: 02/12/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: HA Date: 09-11-23 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3886	B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

FLOW WATER JET

1-Cut as per Dwg D3886-3

Dwg Rev: BProg Rev: B

2-Deburr if necessary

HB 9-12-8

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

HB 9-12-8

Pho 7

Dart Aerospace Ltd

W/O: 53920		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/12/08	#120	Took Qty +1 for QC inspection template	S	9/12/08	4		 09/12/08

Part No: D3886-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53920

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Page 2

Item ID: D3886-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 23/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



⇒ 8 or 12/10

QC

Memo

0.00

Quality Control

(47)

Truck
Qty 4

Per
Template
5

130

0.00



Brake NC

Memo

0.00

SB 09/12/14

Brake NC

form as per dwg D3886

(7)

0

140

QC5- Inspect part completeness to step on W/O

0.00



⇒ 8 or 12/14

QC

Memo

0.00

Quality Control

(47)

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53920

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Page 3

Item ID: D3886-041

Accept

Setup Start

Revision ID: B

Stop

Item Name: Lug Assembly

Start Date: 23/11/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

0.00



Large Fab

Large Fab

Memo

Weld as per Dwg D3886 and QSI 004
A/R SS ROD Batch: H 102421

0.00

2 09 12 14

(7x)

160

0.00



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

(X7)

lpd 09/12/15

170

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

27 8 09/12/16

(X7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53920

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Page 4

Item ID:	D3886-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug Assembly					
Start Date:	23/11/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	02/12/2009	Req'd Qty: 4.00		Customer:		

Reference:						Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:			Stop	
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START 2:10 OVENT. 400° FINISH 2:40	0.00 0.00		BR 09-12-21.		⑦			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		M 09-12-21		⑦	Ø		
200 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00				9/12/00	⑦	SP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53920

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Item ID: D3886-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 23/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/22 [Signature]

C209112122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 2:49:41 PM

Page 1

Work Order ID: 53920

Parent Item: D3886-041RevB

Parent Item Name: Lug Assembly

Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S12GA		Purchased	No			100	sf	224.0000	6.0800	1.2		
304/316 0.100" Sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

Adj - 16'
 yuf

MAT 112290
112611
113062
113077

224
64
128
32

112290

D3886-1RevB

Manufactured No

150

Each

10.0000

4.0000

Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

10

52646

10

B47479

x2

9-12-14

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

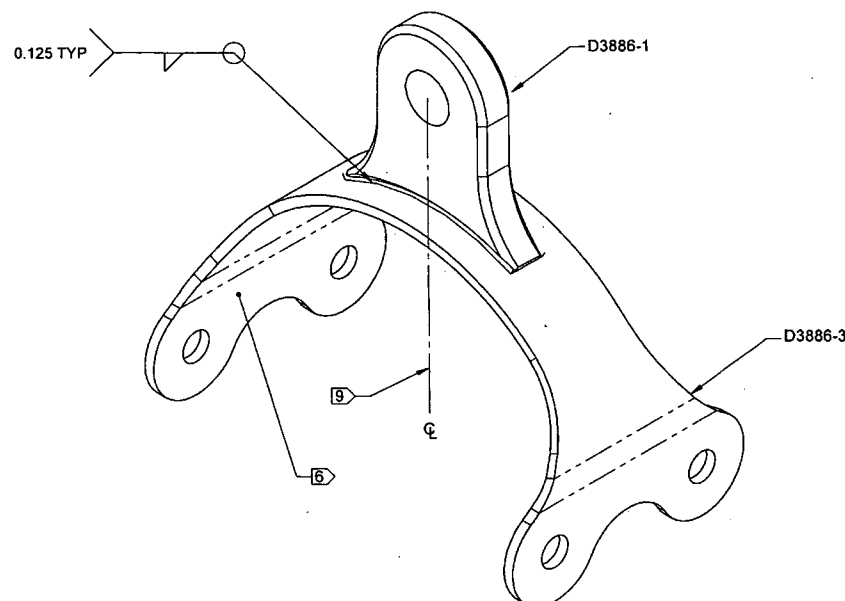
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

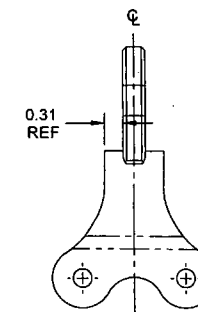
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



D3886-041 LUG ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53920
Bf09-11-23

RELEASED
8/6/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

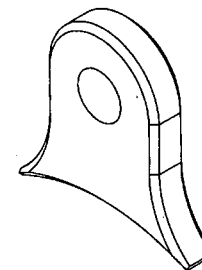
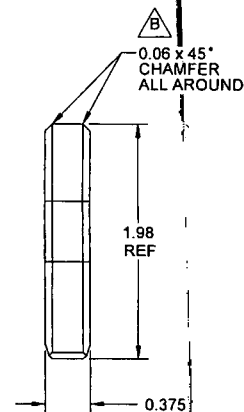
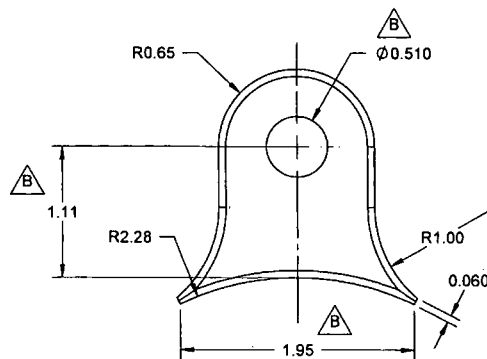
B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3886** REV. B
SHEET 1 OF 4

TITLE **LUG ASSEMBLY** SCALE NTS

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D3886-1 LUG (B)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
07/15/14

W/10 53920

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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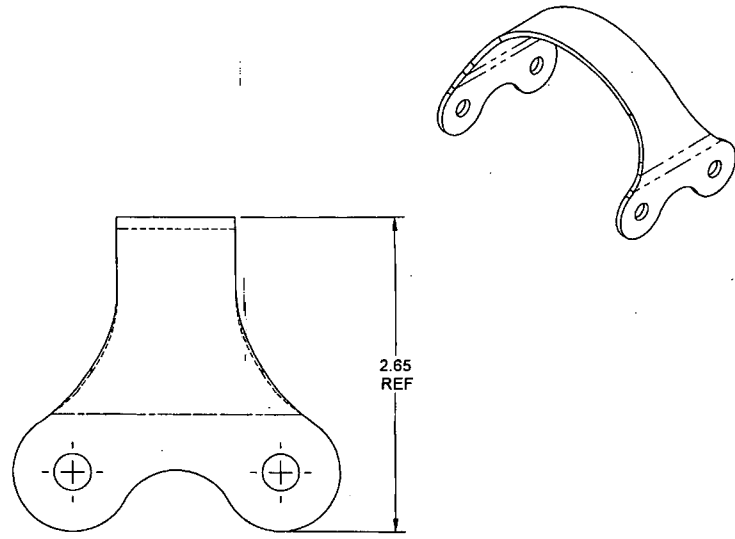
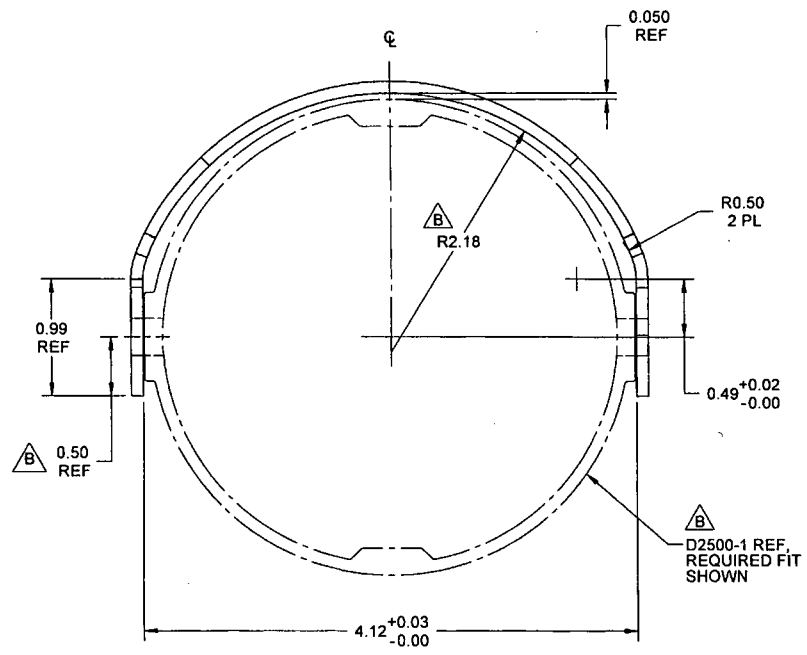
8 7 6 5 4 3 2 1

D

C

B

A



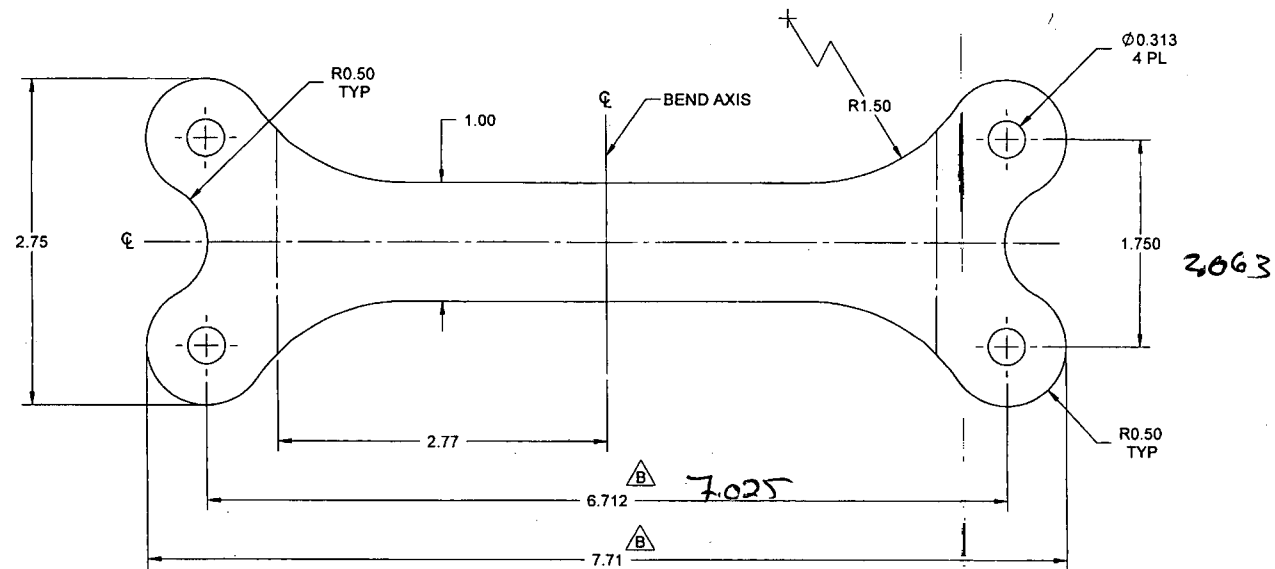
D3886-3 BRACKET
(MAKE FROM D3886-3F)

RELEASED
09/07/1920

W10 53920

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, VA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3886-3F FLAT PATTERN B

RELEASED
9/6/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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w/o 53920